

Date: Monday, 6/19/2006 11:26:56 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI ACCESS STEP HIGH GEAR LH
<b>Job Number</b> : 27621	
<b>Estimate Number</b> : 12434	
<b>P.O. Number</b> : NIA	<b>Part Number</b> : D205633021
<b>This Issue</b> : 6/19/2006 <b>S.O. No.</b> : NIA	<b>Drawing Number</b> : DSI 9300 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : NIA <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 27393	<b>Material</b> : NIA
<b>Written By</b> : <i>SA COMMENT BELOW</i>	<b>Due Date</b> : 7/10/2006 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>06.06.19</i>	
<b>Comment</b> : Est Rev:B Added D2565-111 05-09-09 KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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②

<b>Comment:</b> Photocopy bluefile & type labels per PPPD205-633-021	CHG001
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K-9 06.06.26

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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<b>Comment:</b> PACKAGING RESOURCE #1
Pick Packing Kit

3.0	D2022101	Spacer
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<b>Comment:</b> Qty.: 4.0000 Each(s)/Unit	Total : 8.0000 Each(s)
Spacer	
Batch: B 25815	✓

4.0	D2022103	Spacer
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<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit	Total : 4.0000 Each(s)
Spacer	
Batch: B 25967	✓

5.0	D2562011	Strut
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<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit	Total : 2.0000 Each(s)
Strut	
Batch: B 27403	✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:26:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 27621

Part Number: D205633021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2563

Step Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Step Weldment Assembly

Batch: B 27646

7.0

D2565101

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: B 27165 ✓

8.0

D2565103

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: B 27405 ✓

9.0

D2565105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: B 27406 ✓

10.0

D2565107

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: B 25924 ✓ ~~(B 27407 (+))~~

11.0

D2565109

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: B 27166 ✓

12.0

D2565111

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Strut

Batch: B 26448 ✓

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:26:56 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 27621

Part Number: D205633021

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D3437041

Aft Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Aft Strut Assembly

Batch: B 27415 ✓

14.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M 100857U

15.0

AN46A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M 19278 ✓

16.0

AN47A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M 19278 ✓

17.0

AN411A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M 17771 ✓

18.0

AN414A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M 100188 ✓

19.0

AN447A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BOLT

Batch: M 14781 ✓

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Monday, 6/19/2006 11:26:57 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 27621

Part Number: D205633021

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN514A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m 17566 ✓

21.0

AN960JD416

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: m 101369 ✓

22.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

Batch: m 19185 ✓

23.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Nut

Batch: m 19085 ✓

24.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: m 17694 ✓

CS 6/17/6 (2)

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Ref 17 (2)

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-633-021

Location:

PPP Rev: DIAF+

Ref 17 (2)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_

NOTE: Date & initial all entries

NCR: Yes ☒ No ☐ DQA:   D   Date: 06/07/07  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



Date: Monday, 6/19/2006 11:26:57 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP HIGH GEAR LH

Job Number: 27621

Part Number: D205633021

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

②  
S 06/07/07

Job Completion



u 06.07.07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector



NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 1 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS
A	05.05.05	NEW ISSUE	
B	05.08.12	ADD STRUTS IF TANK REMOVED	

## DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-633 REV. A

REF. CANADIAN STC: SH96-57

REF. FAA STC: SR00592NY, SR00593NY, SR00594NY

THE PURPOSE OF THIS SERVICE INSTRUCTION IS TO ADD THE D205-633-021/-022/-023/-024/-025/-026 STEPS TO ADDRESS COMPATABILITY WITH THE SIMPLEX MODEL 304 FIRE ATTACK TANK. D205-633-021/-022 ARE IDENTICAL TO D205-633-011, EXCEPT AS SHOWN HERE. D205-633-023/-024 ARE IDENTICAL TO D205-633-013, EXCEPT AS SHOWN HERE. D205-633-025/-026 ARE IDENTICAL TO D205-633-015, EXCEPT AS SHOWN HERE.

NOTE THAT THE STRUTS REQUIRED TO INSTALL THE STEPS ON THE LOWER AFT HARDPOINT HAVE ALSO BEEN INCLUDED WITH THE KITS IN CASE THE TANK IS REMOVED FOR ANY REASON. THESE STRUTS SHOULD BE INSTALLED I.A.W. IIN-D205-633, EXCEPT REPLACE EYEBOLT WITH AN4 BOLT ON LOWER HARDPOINT. ALSO NOTE THAT IF THE THREADS PROTRUDE THROUGH THE BAR ON THE D3437-XXX STRUT ASSEMBLIES AFTER ADJUSTMENT THEY MAY BE TRIMMED OFF.

### WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-633-021 <i>HELI-ACCESS-STEP™</i>	14.0 lb 6.35 kg	-50.0 in -1.27 m	-700 in-lb -8.06 m kg	94.5 in 2.40 m	1323 in-lb 15.24 m kg
D205-633-022 <i>HELI-ACCESS-STEP™</i>	13.2 lb 6.00 kg	+50.0 in +1.27 m	+660 in-lb +7.62 m kg	94.5 in 2.40 m	1247 in-lb 14.40 m kg
D205-633-023 <i>HELI-ACCESS-STEP™</i>	14.3 lb 6.50 kg	-50.0 in -1.27 m	-715 in-lb -8.26 m kg	94.5 in 2.40 m	1351 in-lb 15.6 m kg
D205-633-024 <i>HELI-ACCESS-STEP™</i>	13.5 lb 6.14 kg	+50.0 in +1.27 m	+675 in-lb +7.80 m kg	94.5 in 2.40 m	1276 in-lb 14.74 m kg
D205-633-025 <i>HELI-ACCESS-STEP™</i>	14.6 lb 6.64 kg	-50.0 in -1.27 m	-730 in-lb -8.43 m kg	94.5 in 2.40 m	1380 in-lb 15.94 m kg
D205-633-026 <i>HELI-ACCESS-STEP™</i>	13.8 lb 6.27 kg	+50.0 in +1.27 m	+690 in-lb +7.96 m kg	94.5 in 2.40 m	1304 in-lb 15.05 m kg

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AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**



BY:   
D. SHEPHERD (DE # 02)

DATE: 05.08.12  
CERT. NO.: SH96-57  
ISSUE NO.: #5

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DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 2 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS

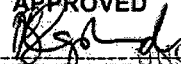
**PARTS LIST**

QTY -021	QTY -022	QTY -023	QTY -024	QTY -025	QTY -026	Part Number	Description
X						D205-633-021	Hell-Access-Step™ (LH), High Gear
	X					D205-633-022	Hell-Access-Step™ (RH), High Gear
		X				D205-633-023	Hell-Access-Step™ (LH), Extended High Gear (31")
			X			D205-633-024	Hell-Access-Step™ (RH), Extended High Gear (31")
				X		D205-633-025	Hell-Access-Step™ (LH), Extended High Gear (39")
					X	D205-633-026	Hell-Access-Step™ (RH), Extended High Gear (39")
4	4	4	4	4	4	D2022-101	SPACER
2	2	2	2	2	2	D2022-103	SPACER
				1	1	D2562-005	STRUT
1	1					D2562-011	STRUT
		1	1			D2562-013	STRUT
1		1		1		D2563	WELDMENT ASSEMBLY
				*1	*1	D3165-1	STRUT
1	1					D2565-101	STRUT
1	1					D2565-103	STRUT
1	1					D2565-105	STRUT
1	1					D2565-107	STRUT
1	1					D2565-109	STRUT
*1	*1					D2565-111	STRUT
		1	1			D2565-201	STRUT
		1	1			D2565-203	STRUT
		1	1			D2565-205	STRUT
		1	1			D2565-207	STRUT
		1	1			D2565-209	STRUT
		*1	*1			D2565-211	STRUT
				1	1	D2565-301	STRUT
				1	1	D2565-303	STRUT
				1	1	D2565-305	STRUT
				1	1	D2565-307	STRUT
				1	1	D2565-309	STRUT
1	1					D3437-041	AFT STRUT ASSEMBLY
		1	1			D3437-043	AFT STRUT ASSEMBLY
				1	1	D3437-045	AFT STRUT ASSEMBLY
	1		1		1	D3438-042	WELDMENT ASSEMBLY
1	1	1	1	1	1	AN4-5A	BOLT
4	4	3	3	3	3	AN4-6A	BOLT
1	1	1	1	1	1	AN4-7A	BOLT
1	1					AN4-11A	BOLT
		1	1	1	1	AN4-12A	BOLT
1	1	1	1	1	1	AN4-14A	BOLT
1	1	1	1	1	1	AN44-7A	EYEBOLT
1	1	1	1	1	1	AN5-14A	BOLT
16	16	14	14	14	14	AN960JD416	WASHER
3	3	3	3	3	3	AN960JD516	WASHER
8	8	7	7	7	7	MS21042L4	NUT (or MS21042-4)
2	2	2	2	2	2	MS21042L5	NUT (or MS21042-5)

\* ONLY INSTALLED IF TANK IS REMOVED

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DAO # 01-O-01APPROVED  
BY:   
D. SHEPHERD (DE # 02)  
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CERT. NO.: SH96-57  
ISSUE NO.: #5  
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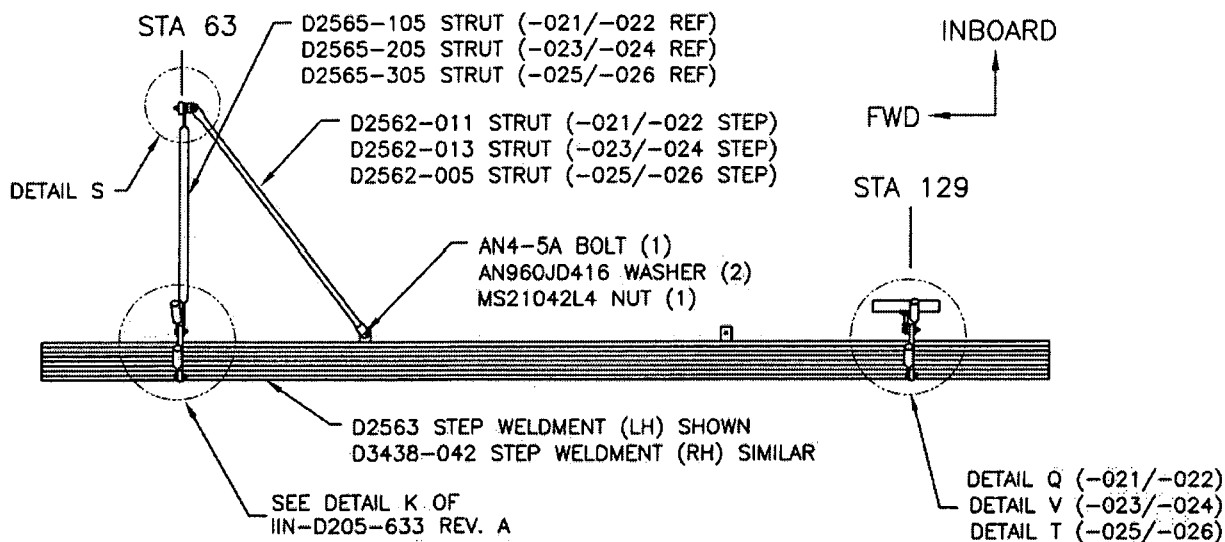
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9300	REV. B 3 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP KIT	SCALE NTS

### INSTALLATION OF D205-633-021/-022/-023/-024/-025/-026

INSTALL D205-633-021/-022 AS PER THE D205-633-011 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-111 STRUT WITH THE D3437-041 AFT STRUT ASS'Y, REMOVE D2562-001 STRUT, INSTALL D2562-011 STRUT AS SHOWN.

INSTALL D205-633-023/-024 AS PER THE D205-633-013 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D2565-211 STRUT WITH THE D3437-043 AFT STRUT ASS'Y, REMOVE D2562-003 STRUT, INSTALL D2562-013 STRUT AS SHOWN.

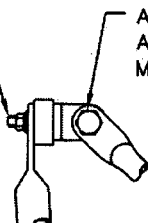
INSTALL D205-633-025/-026 AS PER THE D205-633-015 STEP OF INSTALLATION INSTRUCTIONS IIN-D205-633 REV.A, EXCEPT REPLACE D3165-1 SUPPORT ARM WITH THE D3437-045 AFT STRUT ASS'Y AS SHOWN.



**D205-633-021/-023/-025 SHOWN.**  
**D205-633-022/-024/-026 SIMILAR**  
(VIEW LOOKING DOWN)

AN44-7A EYEBOLT (1)  
AN960JD516 WASHER (1)  
MS21042L5 NUT (1)

**DETAIL S**  
NOT TO SCALE



AN4-6A BOLT (1)  
AN960JD416 WASHER (2)  
MS21042L4 NUT (1)

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BY: *[Signature]*  
D. SHEPHERD (DE # 02)

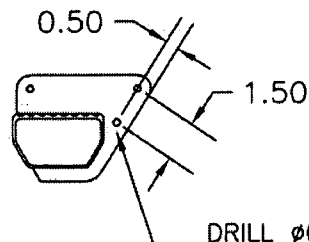
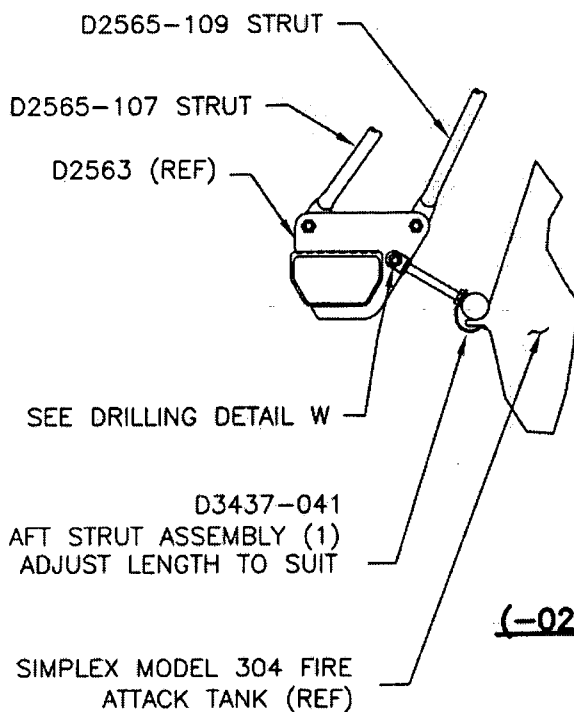
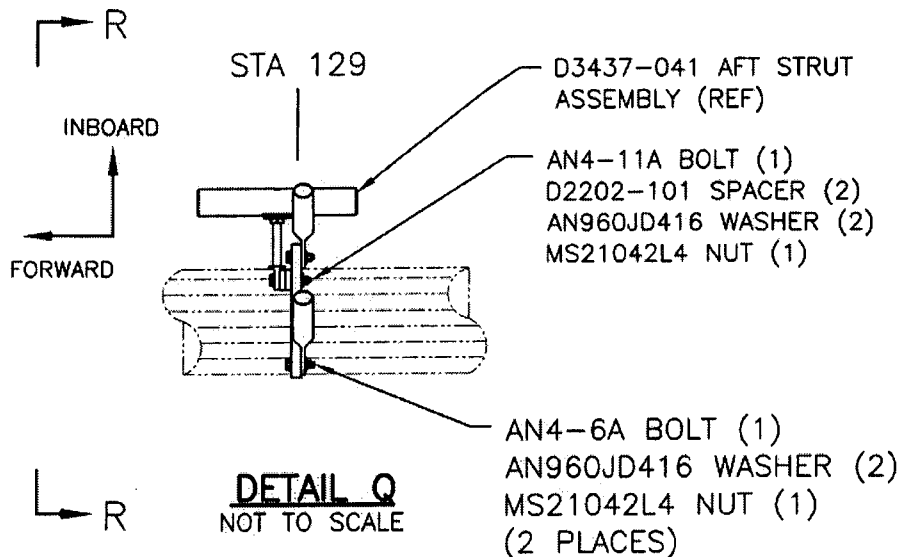
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DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



DRILL  $\varnothing 0.257$  THRU,  
TOUCH UP WITH  
ALODINE 1200 OR 1201  
PER MIL-C-5541 AS SHOWN

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**VIEW R-R**  
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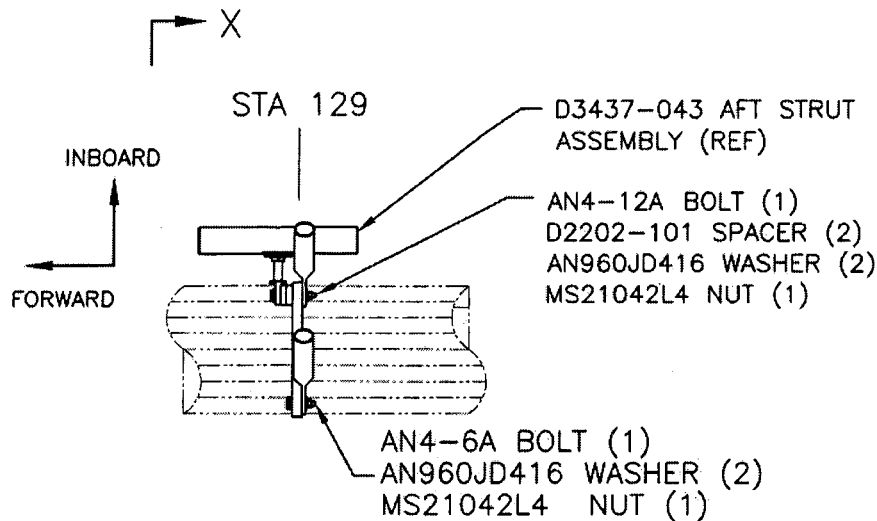
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
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BY:	D. SHEPHERD (DE # 02)
DATE:	05.08.12
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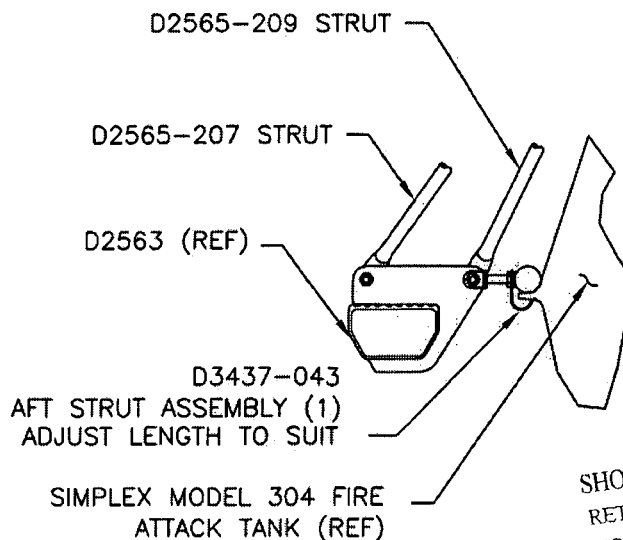
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CHECKED 	APPROVED 	DRAWING NO. DSI 9300	REV. B SHEET 5 OF 6
DATE 05.08.12		TITLE SIMPLEX TANK STEP	SCALE NTS



**DETAIL V**  
NOT TO SCALE



**(-023/-024 STEP)** UNCONTROLLED COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 27621

**VIEW X-X**  
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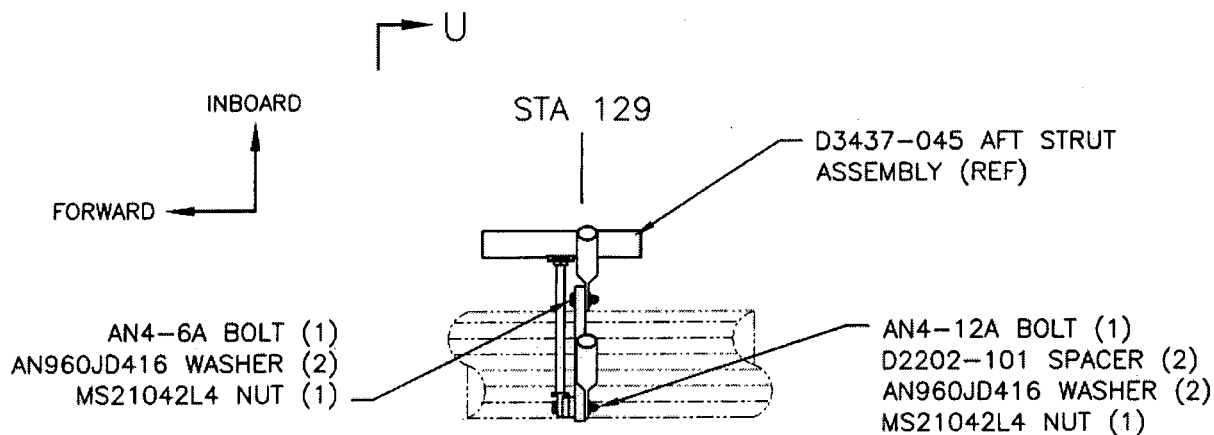
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
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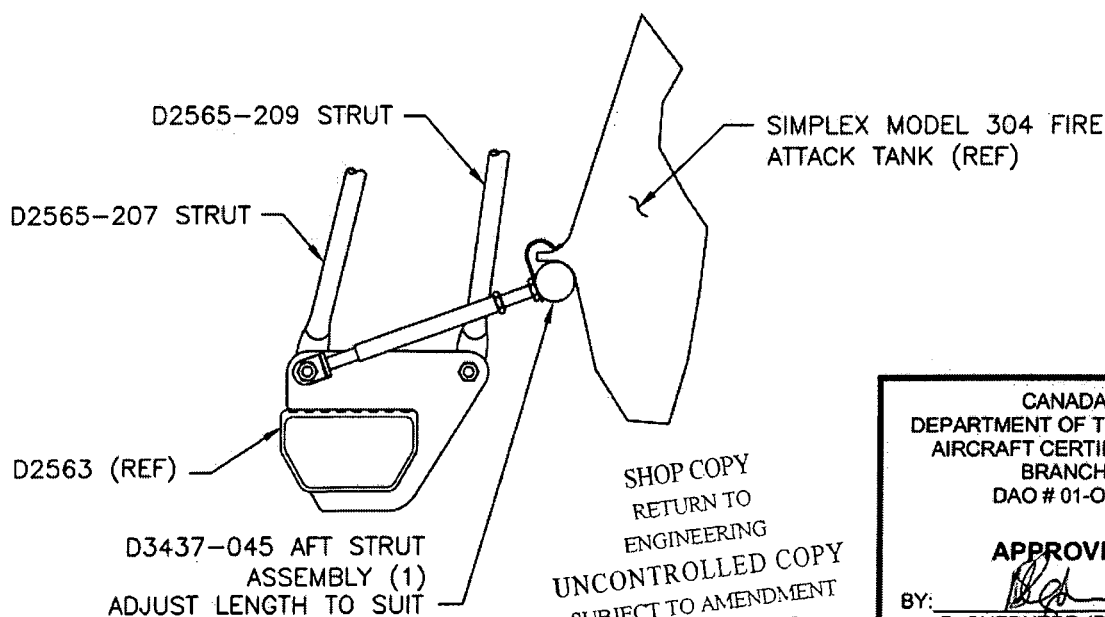
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